

**Work Order ID 110152****\*110152\***

Page 1

Item ID: D3913-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-18

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	C								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: _____ Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh***  2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends  3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket***  4- Weld D4672-1 blanking plates as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

1x DAS  
43  
9-89 14-01-15

① 14-01-17 DAS  
9  
9-89

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Page 2

1 MG 14/1/20

# Work Order ID 110152

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**\*110152\***

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Item ID: D3913-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Long Basket Base Assembly, 350  
Start Date: 12/12/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 12/17/13 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*130*</b>	<i>m 126859.</i>					<i>1</i>	<i>φ</i>	<i>14-1-20</i>	DAS
Powdercoat	Memo	0.00							34
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat								9-89
	1ST COAT: START TIME: <i>11:10</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>11:40</i> ***** 2nd coat if necessary*****								
	2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*1x φ 14 11/20*

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Item ID: D3913-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: w/b

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

D4030-041/13110164

1 x / / SL 14/01/20

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Item ID: D3913-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

14-01-22

14-01-21



# Picklist Print

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Page 1

Work Order ID: 110152

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP  
REV:D 13.08.21 DWG REV.C/ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3913-1 Rib		Manufactured	No			100	Each	3.0000	1	1		DAS 43 14.01.14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		3							
				103617		1							
				103755		2							
✓ D3913-3 Rib		Manufactured	No			100	Each	0.0000	1	1		DAS 43 14.01.14	
✓ D3913-7 Rib		Manufactured	No			100	Each	3.0000	2	2		DAS 43 14.01.14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		3							
				94828		3							
✓ D3913-9 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1		DAS 43 14.01.14	
✓ D3916-5 Light Rib		Manufactured	No			100	Each	9.0000	3	3		DAS 43 14.01.14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		9							
				107317		8							
				107318		1							
- D3916-041 Rib Assembly		Manufactured	No			100	Each	6.0000	2	2		DAS 43 14.01.14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		6							
				106740		4							
				107999		2							





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Work Order ID: 110152

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-7 Rib Manufactured No 100 Each 20.0000

Location	Loc Qty	Loc Code
WA004	20	
106799	2	
107296	18	

<sup>3</sup>  
B 107296 → 3x  
DAS 43 14.01.14  
9-89

✓ D4017-9 Rib Manufactured No 100 Each 4.0000

Location	Loc Qty	Loc Code
WA004	4	
107394	4	

<sup>2</sup>  
B 106299 → 2x  
DAS 43 14.01.14  
9-89

✓ D4034-041 Aft Upper Rib Assembly Manufactured No 100 Each 5.0000

Location	Loc Qty	Loc Code
WA004	5	
106006	1	
106357	4	

<sup>1</sup>  
B 106665  
DAS 43 14.01.14  
9-89

✓ D4034-043 Fwd Upper Rib Assembly Manufactured No 100 Each 5.0000

Location	Loc Qty	Loc Code
WA001	4	
106655	4	
WA004	1	
105994	1	

<sup>1</sup>  
B 106353  
DAS 43 14.01.14  
9-89

✓ D2581 Mounting Bracket Manufactured No 100 Each 264.0000

Location	Loc Qty	Loc Code
WA004	264	
102265	94	
103683	98	
105886	48	
107768	24	

<sup>2</sup>  
B 107768 → 2x  
DAS 43 14.01.14  
9-89

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Work Order ID: 110152

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D2931	Manufactured	No	150	Each	2,080.0000	2	2	DAS 32 <del>3-89</del>
Bumper								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	82	
46064	82	
ST021	1998	
86435	1998	

* D3913-15	Manufactured	No	100	Each	30.0000			86435 1 B1035168 DAS 43 14-01-14 <del>3-89</del>
Wide Handle Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	30	
102500	4	
102934	4	
103568	8	
107769	14	

✓ D4016-1	Manufactured	No	100	Each	48.0000			3 B110038 → 3x DAS 43 14-01-14 <del>3-89</del>
Hinge Half, Base								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	48	
104200	20	
106646	20	
107938	8	

✓ D4021-1	Manufactured	No	100	Each	35.0000			3 B107621 → 2x 107253 → 1x DAS 43 14-01-14 <del>3-89</del>
Handle Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	35	
103509	7	
107253	12	
107621	8	
108008	8	

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Work Order ID: 110152

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4021-5  
Blanking Plate

Manufactured No

100 Each 18.0000

2 2

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST083

18

103829

6

107129

3

107549

8

85065

1

107549

✓ D4020-11  
End Mesh, Basket

Manufactured No

100 Each 16.0000

2 2

DAS  
43  
9-89

Location

Loc Qty

Loc Code

WA004

16

100330

16

2 2  
B100330 → 2x

14-01-14

✓ D4672-1  
Blanking Plate

Manufactured No

100 Each 19.0000

2 2

Location

Loc Qty

Loc Code

WA004

19

100820

8

107975

11

2 2  
B107975 → 2x

DAS  
43  
9-89

14-01-14

✓ M304EX0.75-16F  
Expanded Metal Flat SS

Purchased No

100 sf 1,316.2736

33 33

Location

Loc Qty

Loc Code

WA004

1316.273598

M126052

39.4435977

M126500

73.83

M126899

99

M127024

640

M127403

464

33 33  
M127795 → 33

DAS  
43  
9-89

14-01-14

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Work Order ID: 110152

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,287.0000

2

2

DAS  
32  
9.89

Cherry Rivets

Location

Loc Qty

Loc Code

ST311

1154

112794

40

122151

4

122452

4

123525

282

124231

91

m127476

733

M/27476

WA003

133

107939

133

MS21042L3

Purchased

No

150

Each

6,342.0000

6

DAS  
32  
9.89

Nut

Location

Loc Qty

Loc Code

GA

194

M126333

194

ST314

28

M126036

28

ST506

793

123900

793

ST509

4000

M127304

1000

M127410

3000

ST510a

1327

M126275

8

M126333

1319

M/27831 14/01/20

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Work Order ID: 110152

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

5,834.0000

12

12

32  
9-89

Washer

Location

Loc Qty

Loc Code

GA

182

122063

182

ST294

158

122063

158

ST295

494

123352

3

123900

491

ST510a

5000

125646

5000

125646

DAS  
32  
9-89

AN3-10A

Purchased

No

150

Each

187.0000

6

6

32  
9-89

Bolt

Location

Loc Qty

Loc Code

ST351

4

124221

3

124858

1

ST513

183

m125709

183

m125709

DAS  
32  
9-89

NAS1149DN832J

Purchased

No

150

Each

2,507.0000

2

2

32  
9-89

Washer

Location

Loc Qty

Loc Code

ST293

20

M126221

20

st510

398

124555

398

ST510a

2089

M126319

1089

M127255

1000

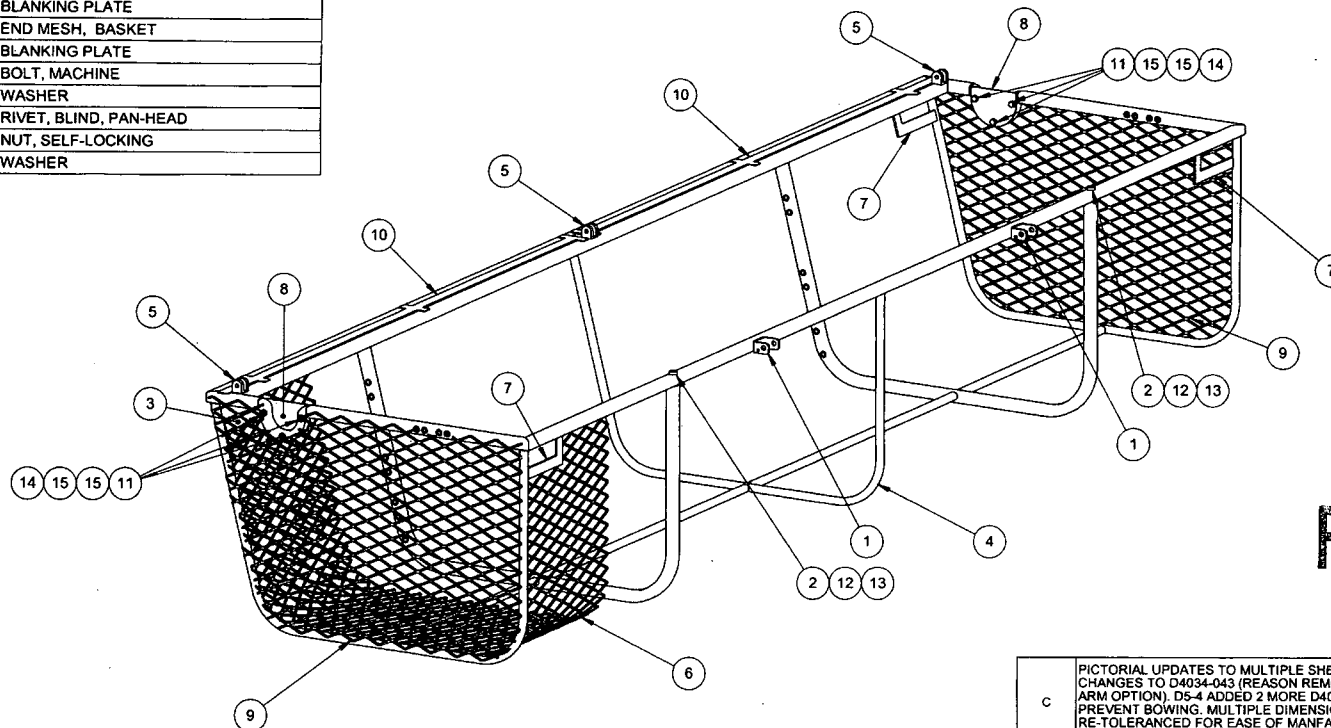
m126319

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Shop Packet Print

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	3	D4021-1	HANDLE PLATE
8	2	D4021-5	BLANKING PLATE
9	2	D4020-11	END MESH, BASKET
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

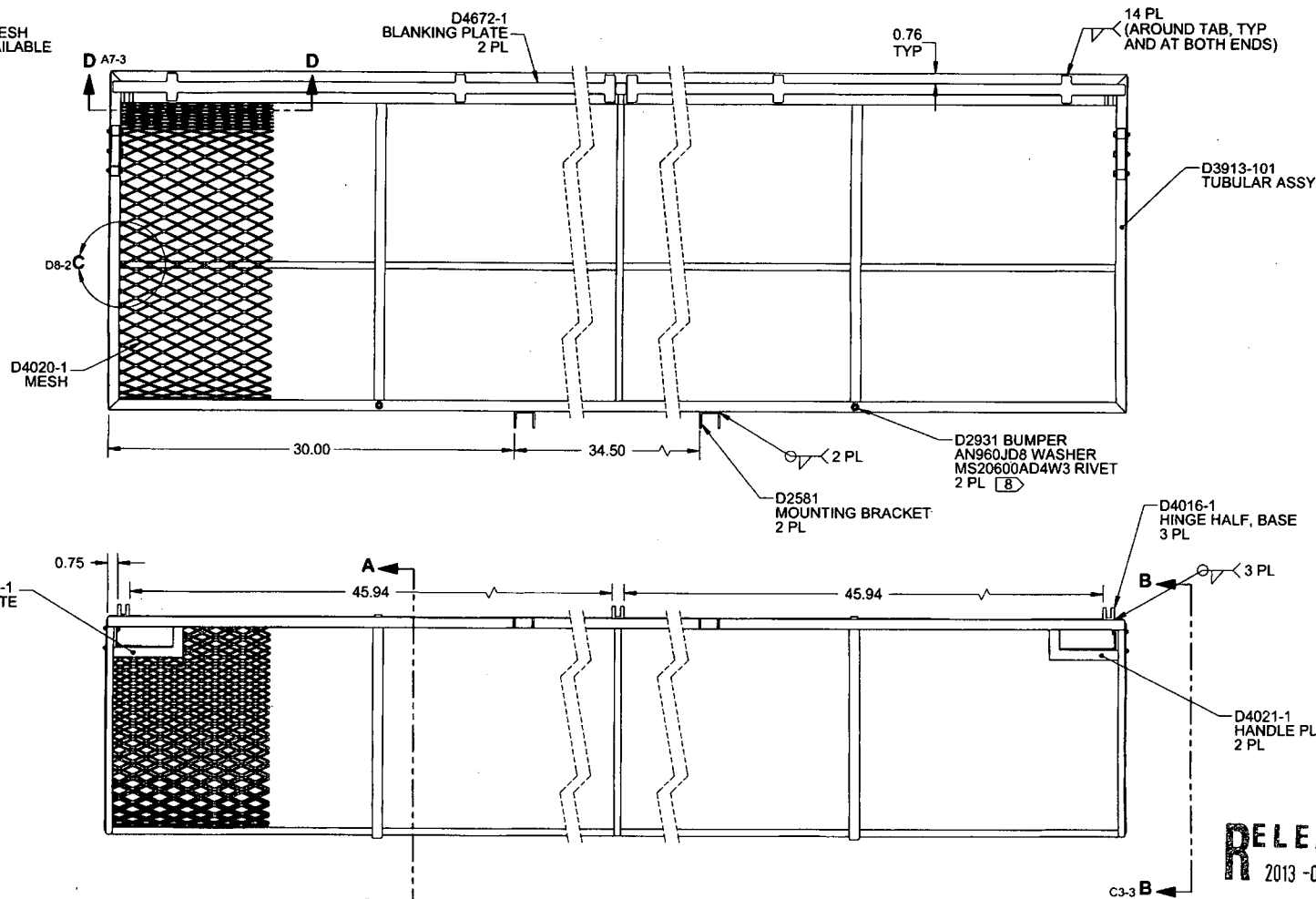
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2013-08-16

C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PART12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JP		
MFG APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.07.18		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3913</b> TITLE <b>LONG BASKET BASE ASSY (350)</b> SCALE NTS SHEET 1 OF 6 REV. C <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			




TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

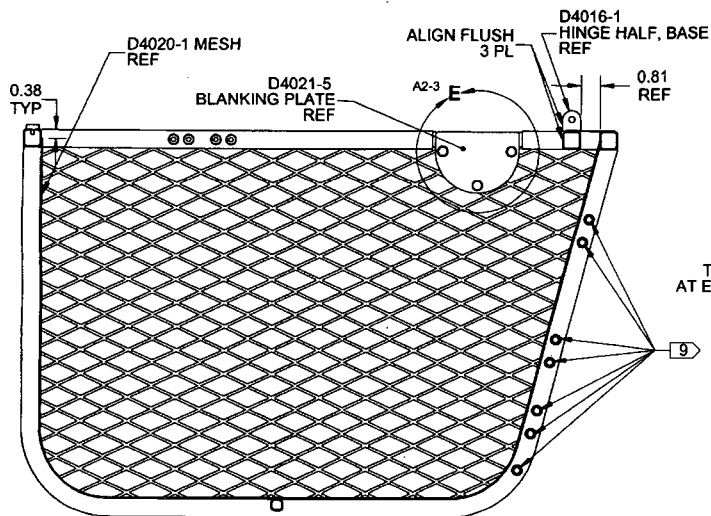
**DETAIL C** D7-2  
SCALE: 2X



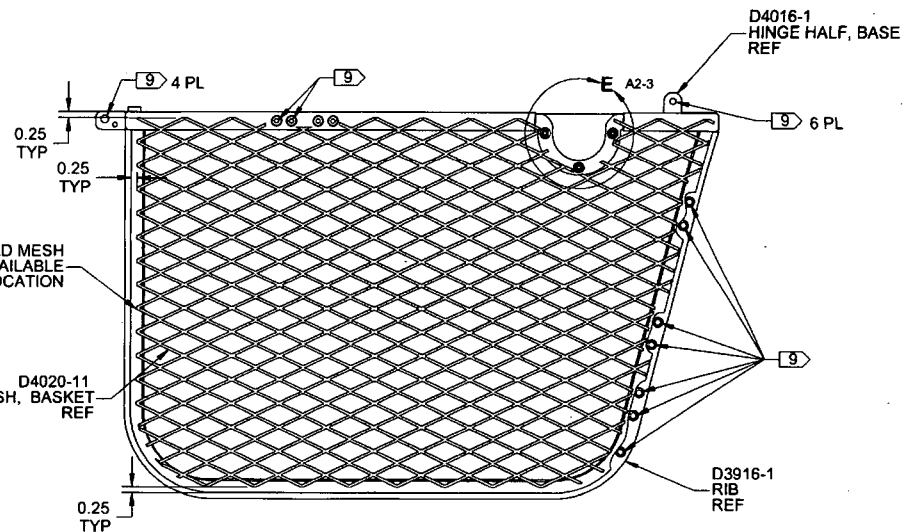
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2013-08-16

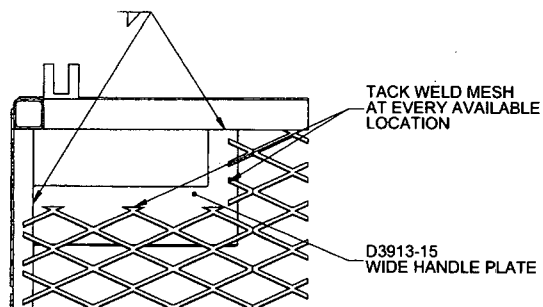
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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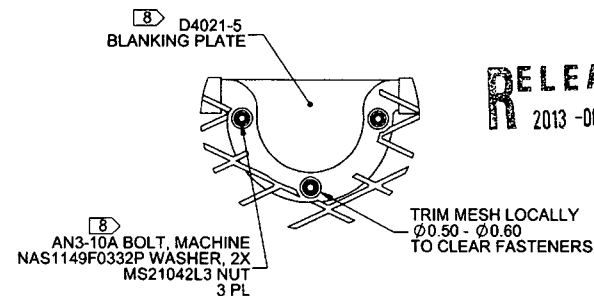
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D6-2  
TYPICAL FOR ALL  
HANDLE PLATES



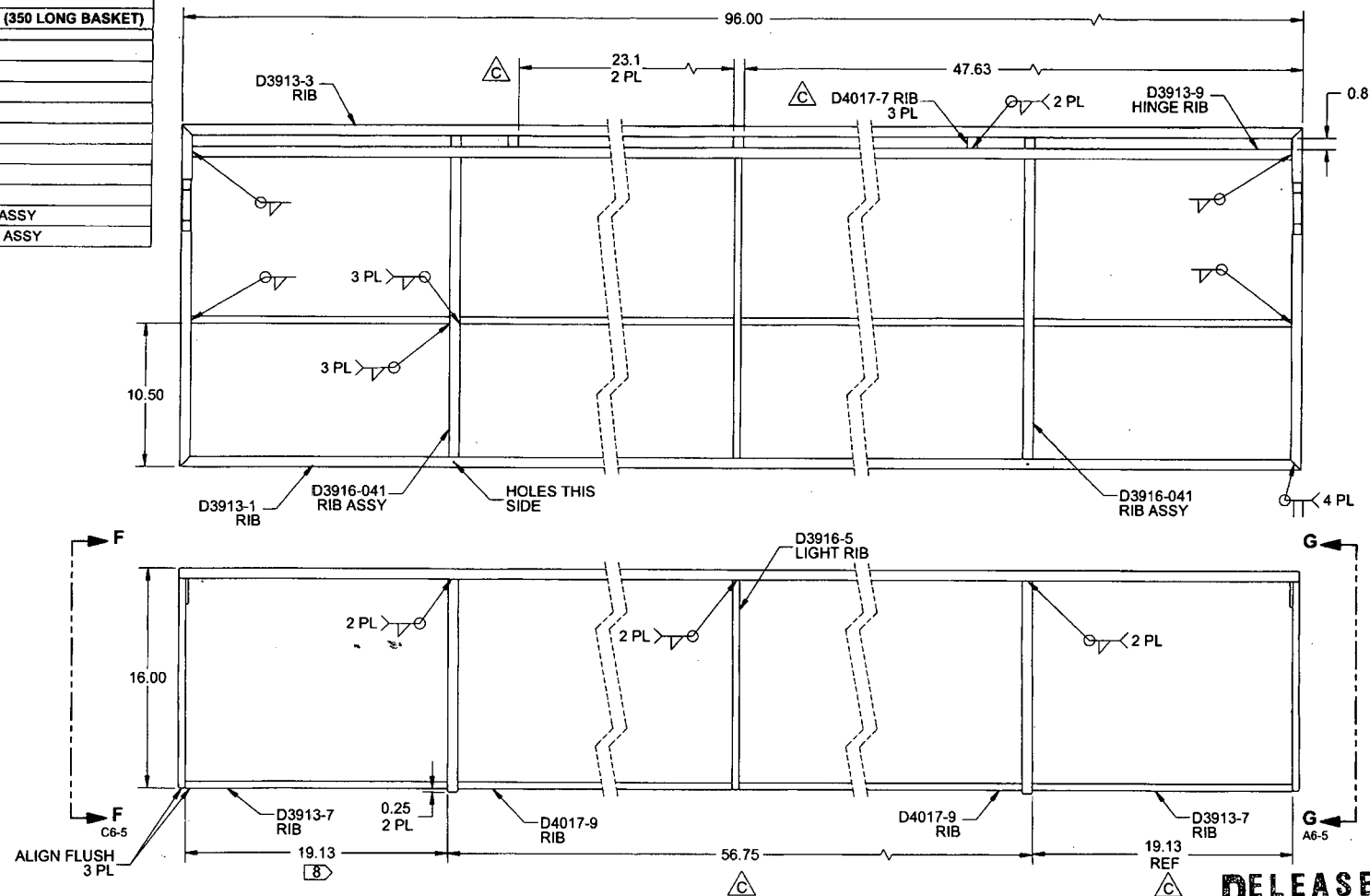
**DETAIL E** D2-3  
D6-3

**RELEASED**  
2013-08-16  
MD

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3913</b>	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350) NTS</b>	
DATE	<b>13.07.18</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



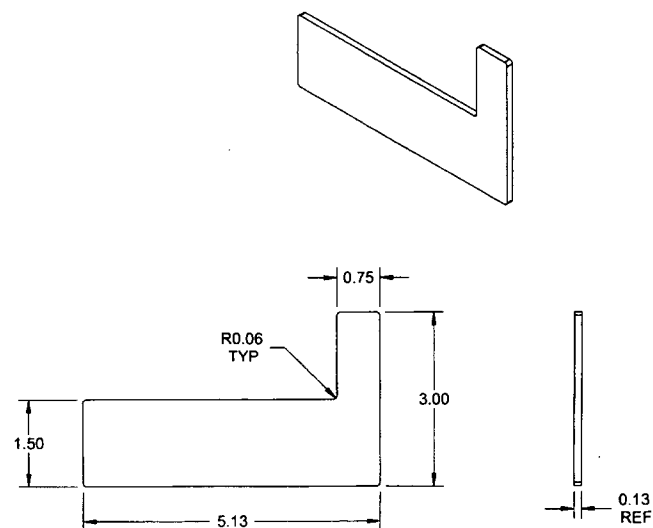
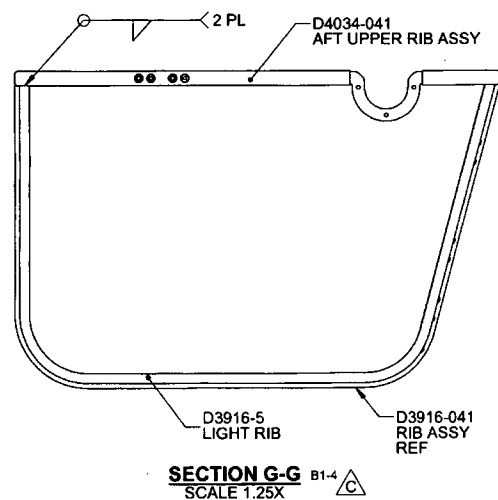
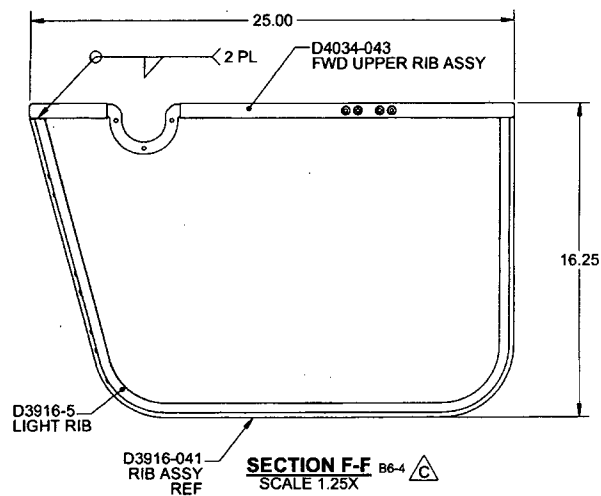
**D3913-101 TUBULAR ASSY (350 SHORT BASKET)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.65 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	DRAWING NO. <b>D3913</b>	REV. C SHEET 4 OF 6
DRAWN	AJS			
CHECKED	<i>[Signature]</i>	TITLE <b>LONG BASKET BASE ASSY (350)</b>	SCALE NTS	
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>	DATE <b>13.07.18</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>			

**RELEASED**  
2013-08-16



# **D3913-15 WIDE HANDLE PLATE**

- NOTES:**  
 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA  
 2) FINISH : NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.31 lbs

**RELEASED**  
 R 2013-08-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3913</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350)</b>	NTS
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